

Work Order ID 69904

Tuesday, May 24, 2011 12:57:40 PM



Page 1

Item ID: D3488-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Blade Fitting Assembly, RH

Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3488	Rev B	FAI REQ B/D

100	DOOSAN LATHE	0.00							
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Dwg DSK 101 & Folio FA627 2-Deburr								

RR 11.6.8

12 0

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

RR 11.6.8

12 0

120	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA627 & Dwg D3488 2-Deburr								

OK 11/10/10

12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng. / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>cmk 11/07/06</i>		<i>12</i>	<i>0</i>		
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>B.A 11/07/06</i>		<i>12</i>	<i>0</i>		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				<i>12</i>	<i>0</i>	<i>BR 11-7-11</i>	

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Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/07/12

11/2

200

Identify as per dwg & Stock Location: FP-8

0.00



Packaging

Memo

0.00

Packaging

11/07/12 11/2

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13
ME
11-07-12

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, May 24, 2011 12:57:46 PM

Page 1

Work Order ID: 69904

Parent Item: D3488-042

Parent Item Name: Blade Fitting Assembly, RH

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-225

Purchased

No

Each

700.0000

48



INSERT

Location

Loc Qty

Loc Code

ST282

700

100896

100

111529

300

111581

300

M 117717

48

D6103-003

Manufactured

No

Each

13.0000

12



Round Billet, Aluminum

Location

Loc Qty

Loc Code

MAT

12

68918

12

MAT043

1

68173

1

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69904
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.148	/		2.62	
Ø2.780	+/-0.005	2.780	/			
Ø3.125	+/-0.010	3.125	/			
Ø3.346	+/-0.010	3.347	/			
0.125 x 45°	+/-0.010 x +/-0.1°	0.125 x 45°	/			
8.000	+0.030/-0.000	8.010	/			
9.250	+/-0.010	9.250	/			
0.188	+/-0.010	.188	/			
R0.032	+/-0.010	.032	/			
R0.062	+/-0.010	.062	/			
Ø0.297	+0.005/-0.001	.290	/			
Ø0.430	+/-0.010	.433	/			
0.100	+/-0.010	.100	/			
0.125	+/-0.010	.130	/			
2.620	+/-0.010	2.617	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	.485	/			
1.180	+/-0.010	1.179	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.070	/			
R0.063	+/-0.010	R2.063	/			

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69909
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø.509	—		Vern HL-7	
0.750	+/-0.010	.750	—		"	
1.500	+/-0.010	1.500	—		"	
11.18	+/-0.030	11.182	—		Vern CMM-02	
R0.062	+/-0.010	R.062	—		R-G	
0.125	+/-0.010	.125	—		Vern HL-7	
0.590	+/-0.010	.590	—		"	
0.793	+/-0.010	.802	—		"	
1.351	+/-0.010	1.350	—		"	
1.317	+/-0.010	1.321	—		"	
1.802	+/-0.010	1.803	—		"	

Measured by:	anf	Audited by:	H.A	Prototype Approval:	N/A
Date:	11/07/06	Date:	11/07/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

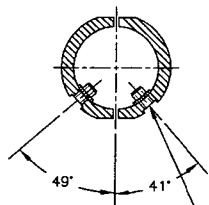
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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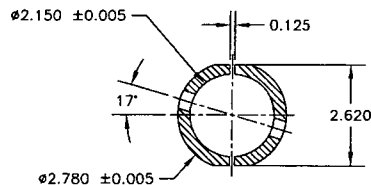
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 69904
PH 11-05-24



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



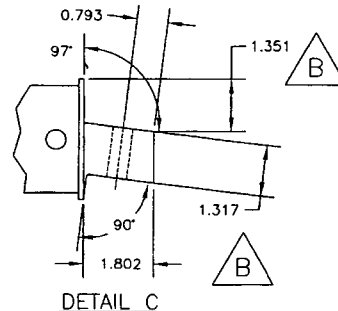
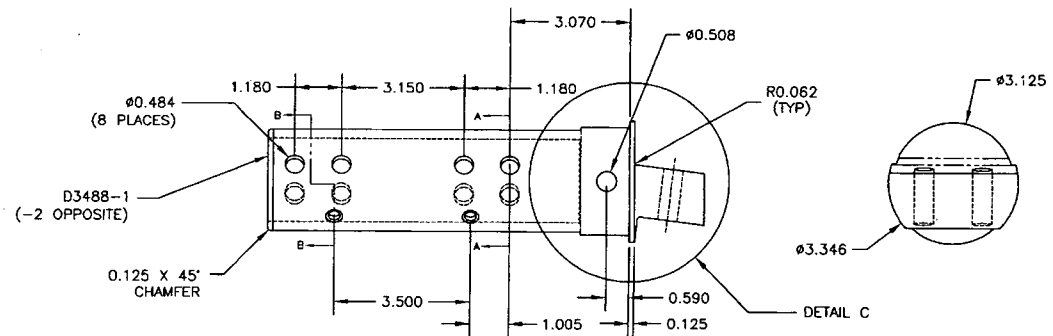
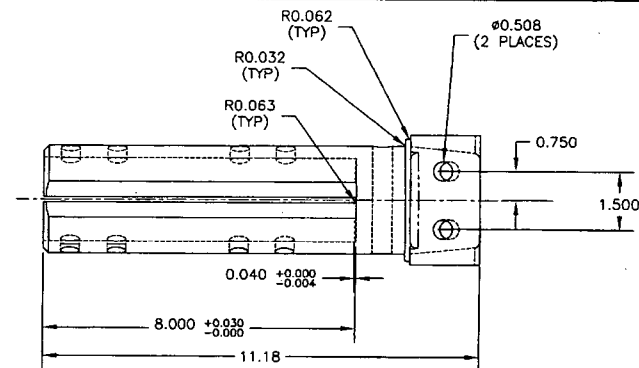
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06-03-15 PH
PER DS
ECN #789

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		SCALE
		1:3

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DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DRAWING NO. D3488 REV. B SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
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